

Work Order ID 50907

July 24, 2009 4:08:14 PM



Page 1

Item ID: D3947-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Panel, Lower LH Post

Start Date: 07/24/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-07-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3947	A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

M111973

BB 09/07/29 *(X4)*

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D3947-3 and Folio FTA 046 using tool DT948411

Dwg. Rev. *A*

Folio Rev. *A*

BB

BB 09/07/29 *(X4)* *(X2)* SCRAP

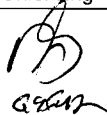
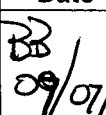
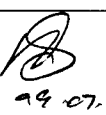
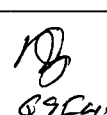
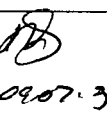
PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/29	110	INCOMPLETE FORMING OF PART Qty x2	 G9F42	ADJUST HEAT PATTERS. IN FOLIO PROGRAM	 09/07/29, 29.07.31	 29.07.31	 G9F42	 09.07.31

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

BB 09/07/30 X4

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DH 09/07/30 X4

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3946-1

BB 09/07/31 X4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID 50907

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Start Date: 07/24/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

B 09/07/31 (X4)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 80207/31

(X4)

4

170

Identify as per dwg & Stock Location: PDP

0.00



Packaging

Memo

0.00

Packaging

50903

44 80207/31

W/O:		WORK ORDER CHANGES					
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Process Plan:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/31 Jg

BB

07/07/31

MF 09-07-31

A

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

July 24, 2009 4:08:13 PM

Page 1

Work Order ID: 50907

Parent Item: D3947-3RevA

Parent Item Name: Panel, Lower LH Post

Comments:

Start Date: 07/24/2009

Required Date: 07/31/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,992.616	14.5011			



GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1992.6166

107574

16.62

111973

797.33

112176

1178.6666

BB 09/07/31

M111973.

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 50907
Description: PANEL LOWEST LH POS	Part Number: D3947-3
Inspection Dwg: D3947 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

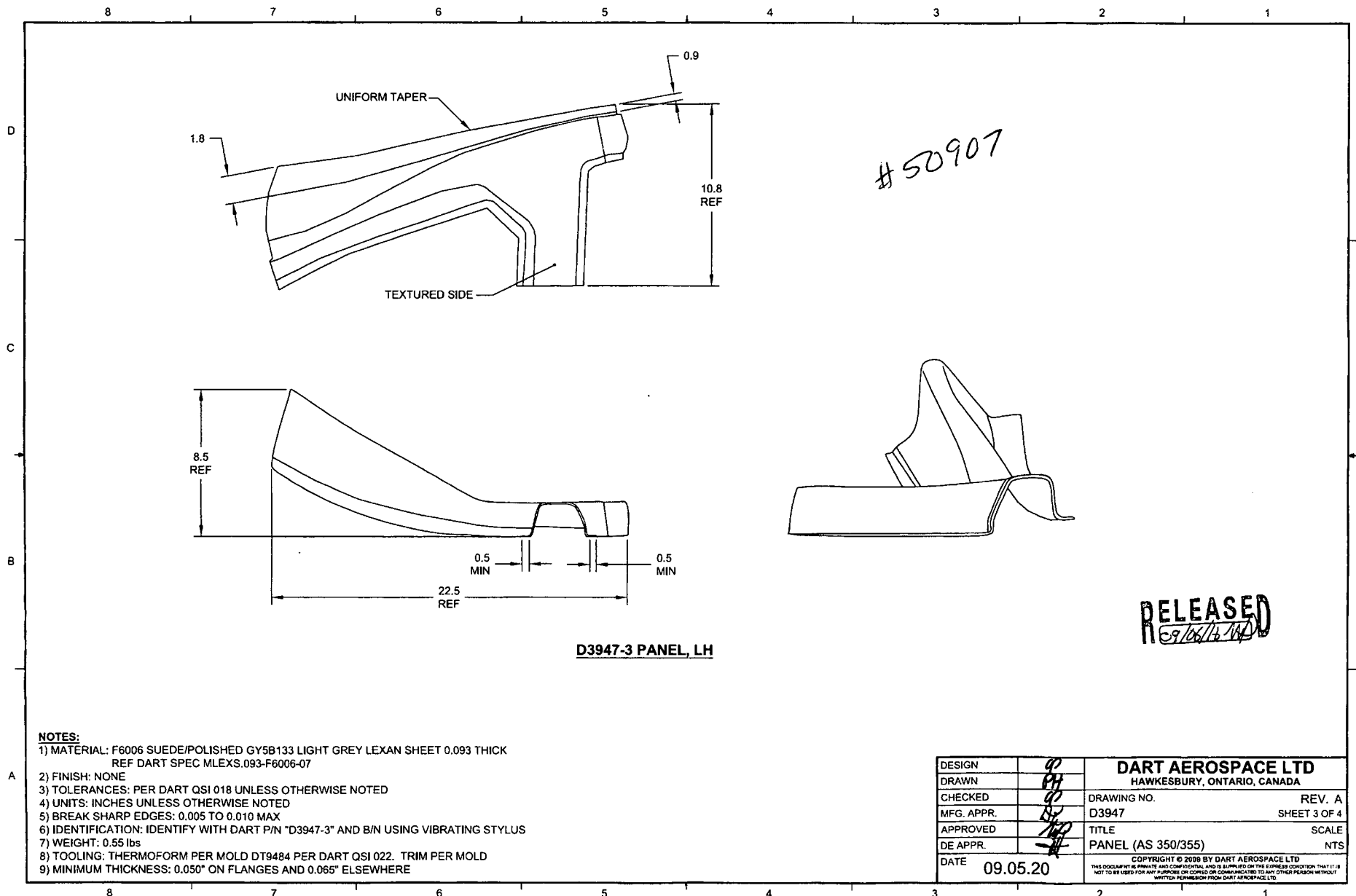
Measured by: BB	Date: 09/07/30
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.5	Min	.599	✓			
0.050	Min	.057	✓			
0.065	Min	.083	✓			
22.5		23	✓			
10.8	REF	11.125	✓			

Measured by: BB	Date: 09/07/30
Audited by: S	Date: 09/07/31
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



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